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**UTILITY PATENT APPLICATION
TRANSMITTAL UNDER 37 CFR 1.53(b)**

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Date: *January 14, 2004*

**NON-POROUS INKJET RECORDING ELEMENT
AND PRINTING METHOD**

031431 U.S. PTO
10/759876

First Named Inventor (or Application Identifier):

Richard J. Kapusniak, et al

Enclosed are:

- | | |
|--|---|
| 1. <input checked="" type="checkbox"/> Specification | 6. <input checked="" type="checkbox"/> Assignment of the invention to Eastman Kodak Company |
| 2. <input type="checkbox"/> Sheet(s) of drawing(s) | 7. <input type="checkbox"/> Certified copy of a priority |
| 3. <input type="checkbox"/> Information Disclosure Statement Under 37 CFR 1.97. | 8. <input type="checkbox"/> Associate Power of Attorney |
| 4. Combined Declaration for Patent Application and Power of Attorney: | |
| 4a. <input checked="" type="checkbox"/> New | |
| 4b. <input type="checkbox"/> Copy from a prior application (37 CFR 1.63(d) (for continuation/divisional with Box 11 completed) | |

5. ☐ Incorporation by Reference (useable if Box 4b is checked) The entire disclosure of the prior application, from which a copy of the oath or declaration is supplied under Box 4b, is considered as being part of the disclosure of the accompanying application and is hereby incorporated by reference therein.

9. ☐ Deletion of Inventor(s).
Signed statement attached deleting inventor(s) named in the prior application, see 37 CFR 1.63(d)(2) and 1.33(b).

10. ☐ If a 111A application prior to examination of the above-identified application, amend the specification at Page 1, after the title, by inserting the following:
--CROSS REFERENCE TO RELATED APPLICATION
Reference is made to and priority claimed from U.S. Provisional Application Serial No. , filed , entitled .

If a CONTINUING APPLICATION, check appropriate box and supply the requisite information:

11. ☐ Continuation ☐ Divisional ☐ Continuation-in-part (CIP) of prior application No. :
12. ☒ Please address all written communications to Paul A. Leipold, Patent Legal Staff,
Eastman Kodak Company, 343 State Street, Rochester, NY 14650-2201.
Please Direct all telephone calls to Chris P. Konkol at 585 722-0452.

The filing fee has been calculated as shown below:

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REGULAR, ORIGINAL FILING

Application Based on

Docket **87568CPK**

Inventors: Richard J. Kapusniak, Charles E. Romano, Jr., Peter J.
Ghyzel, Terry C. Schultz, Lori J. Shaw-Klein

Customer No. 01333

**NON-POROUS INKJET RECORDING ELEMENT AND PRINTING
METHOD**

Commissioner for Patents,
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Date: January 16, 2004

NON-POROUS INKJET RECORDING ELEMENT AND PRINTING

METHOD

CROSS REFERENCE TO RELATED APPLICATIONS

Reference is made to commonly assigned, co-pending U.S. Patent
5 Application Serial Number _____ by Richard J. Kapusniak et al. (Docket
87532) filed of even date herewith, titled "InkJet Recording Element Comprising
Subbing Layer and Printing Method" and U.S. Patent Application Serial Number
_____ by Richard J. Kapusniak et al. (Docket 87005) filed of even date
herewith, titled "Mordanted InkJet Recording Element and Printing Method."

FIELD OF THE INVENTION

The present invention relates to an inkjet recording element and a
printing method using the element.

BACKGROUND OF THE INVENTION

In a typical inkjet recording or printing system, ink droplets are
15 ejected from a nozzle at high speed towards a recording element or medium to
produce an image on the medium. The ink droplets, or recording liquid, generally
comprise a recording agent, such as a dye or pigment, and a large amount of
solvent. The solvent, or carrier liquid, typically is made up of water, an organic
material such as a monohydric alcohol, a polyhydric alcohol or mixtures thereof.

20 An ink-recording element typically comprises a support having on
at least one surface thereof an ink-receiving or image-forming layer, and includes
those intended for reflection viewing, which have an opaque support, and those
intended for viewing by transmitted light, which have a transparent support.

In order to achieve and maintain high quality images on such an
25 image-recording element, the recording element must exhibit no banding, bleed,
coalescence, or cracking in inked areas; exhibit the ability to absorb large amounts
of ink and dry quickly to avoid blocking; exhibit high optical densities in the
printed areas; exhibit freedom from differential gloss; exhibit high levels of image
fastness to avoid fade from contact with water or radiation by daylight, tungsten
30 light, or fluorescent light or exposure to gaseous pollutants; and exhibit excellent
adhesive strength so that delamination does not occur.

Titanium dioxide, zinc oxide, silica and polymeric beads such as crosslinked poly(methyl methacrylate) or polystyrene beads have been used in the receiving layer or layers used in ink recording elements for the purposes of contributing to the non-blocking characteristics of the recording elements or to
5 control the smudge resistance thereof.

U.S. Patent No. 6,447,114 issued September 10, 2002 to Sunderrajan et al., titled "Inkjet Printing Method," uses inorganic pigments in a porous overcoat. The amount of inorganic pigment used may range from about 50 to about 95% of the image-receiving layer. Such particles include silica, alumina,
10 calcium carbonate, modified kaolin clay, montmorillinite clay, hydrotactite clay, and laponite clay.

U.S. Patent Publication No. 2003/0112311 A1 published June 19, 2003 by Naik et al., titled "Method For Decoding A Data Signal," discloses an ink-receptive composition comprising a filler, binder such as polyvinyl alcohol,
15 cationic polymer.

U.S. Patent No 6,341,560 issued January 29, 2002 to Shah et al., titled "Imaging And Printing Methods Using Clay-containing Fluid Receiving Element," discloses a lithographic imaging member that is prepared by applying an ink-jetable fluid to a fluid-receiving element that includes a clay-containing
20 fluid-receiving surface layer. Useful clays that are used are either synthetic or naturally occurring materials, including but not limited to kaolin (aluminum silicate hydroxide) and many other clays such as serpentine, montmorillonites, illites, glauconite, chlorite, vermiculites, bauxites, attapulgites, sepiolites, palygorskites, corrensites, allophanes, imogolites, and others.

25 Aluminosilicates are known in various forms. For example aluminosilicate polymers are known in fiber form, such as imogolite. Imogolite is a filamentary, tubular and crystallized aluminosilicate, present in the impure natural state in volcanic ashes and certain soils; it was described for the first time by Wada in Journal of Soil Sci.. 1979, 30(2), 347-355. In comparison, allophanes are in the
30 form of substantially amorphous particles.

Naturally occurring allophane is a series name used to describe clay-sized, short-range ordered aluminosilicates associated with the weathering of volcanic ashes and glasses. Such natural allophane commonly occurs as very small rings or spheres having diameters of approximately 35 - 50 Å (3.5 to 5.0 nm). This morphology is characteristic of allophane, and can be used in its identification. Naturally occurring allophanes have a composition of approximately $\text{Al}_2\text{Si}_2\text{O}_5 \cdot n\text{H}_2\text{O}$. Some degree of variability in the Si:Al ratios is present. Wada reports Si:Al ratios varying from about 1:1 to 2:1. Because of the exceedingly small particle size of allophane and the intimate contact between allophane and other clays (such as smectites, imogolite, or non-crystalline Fe and Al oxides and hydroxides and silica) in the soil, it has proven very difficult to accurately determine the composition of naturally occurring allophane. Allophane usually gives weak XRD peaks at 2.25 and 3.3 Å. Identification is commonly made by infrared analyses or based on transmission electron morphology.

A limited amount of isomorphous substitution occurs in natural allophane. The most common type is the substitution of Fe for Al. In some cases, the color of this natural allophane is dark yellow due to the presence of Fe^{3+} , the presence of which can interfere with making Raman spectrum of the natural allophane due to the presence of this Fe^{3+} traces (fluorescence under the laser excitation).

Little permanent charge is typically present in natural allophane. The majority of the charge is variable charge, and both cation and anion exchange capacities exist, with the relative amounts depending on the pH and ionic strength of the soil chemical environment.

Synthetic allophane, like natural allophane, is also a substantially amorphous material having weak XRD signals. The particle size (average diameter) typically is in the range of about 4 to 5.5 nm. Due to their small size, it is difficult to obtain a photo of a single unit of synthetic allophane, but they commonly appear substantially spherical, which spheres are usually hollow. The zeta potential of synthetic allophane is positive, which is in the range of other pure

alumina materials. There is data supporting the chemical anisotropy of synthetic allophane, with aluminols at the outer surface, silanols wrapping the inner surface. Aluminosilicate polymers, in spherical particle form, that can be described as synthetic allophanes are disclosed in U.S. Patent No. 6,254,845 issued July 3,
5 2001 to Ohashi et al., titled "Synthesis Method Of Spherical Hollow Aluminosilicate Cluster," which patent describes an improved method for preparing hollow spheres of amorphous aluminosilicate polymer similar to natural allophane. This patent also refers to Wada, S., Nendo Kagaku (Journal of the Clay Science Soc. of Japan), Vol. 25, No. 2, pp. 53-60, 1985) for another synthesis
10 of amorphous aluminosilicate superfine particles. The aluminosilicate polymers in US-A-6,254,845 to Ohashi et al. are within a range of 1-10 nm, shaped as hollow spheres, and are observed to form hollow spherical silicate "clusters" or aggregates in which pores are formed. The patent to Ohashi et al. states that powder X-ray diffraction reveals two broad peaks close to 27° and 40° at 2θ on
15 the Cu-K_α line, which correspond to a non-crystalline (substantially amorphous) structure and which is characteristic of spherical particles referred to as allophane. In addition, observations under a transmission microscope reveal a state in which hollow spherical particles with diameters of 3-5 nm are evenly distributed.

Regarding the Al/Si ratio, it is believed that sufficient silanol group
20 is needed to form an homogeneous layer of silicate on the face of the proto gibbsite sheet, sufficient to curl this protogibbsite sheet and finally allowing a close structure to be obtained. The Al/Si ratio, therefore, has to be in the range 1 to 4.

Two types of synthetic allophane, referred to as hybrid and
25 classical, are disclosed in French Applications FR 0209086 and FR 0209085 filed on July 18, 2002. Hybrid Synthetic allophanes show the same fingerprints as classical allophane with some additional bands due to the presence of organic groups.

As indicated above, synthetic and natural allophane are generally
30 non-crystalline materials, which include both amorphous and short-range ordered materials such as microcrystalline materials. Amorphous materials are at the

opposite extreme from crystalline materials -- they do not have a regularly repeating structure, even on a molecular scale. Their compositions may be regular or, as is more commonly the case, they may have a large degree of variability. They do not produce XRD peaks. Since the term amorphous is sometime applied
5 to materials that are truly amorphous, like volcanic glass, the term x-ray amorphous or simply non-crystalline can be used to describe allophanes and other short-range ordered materials that may show weak XRD peaks and hence not completely amorphous. Such aluminosilicate materials will be referred to herein as substantially amorphous. Short-range ordered materials can sometimes be
10 identified by XRD or selective dissolution in conjunction with differential XRD.

While a wide variety of different types of image recording elements for use with ink printing are known, there are many unsolved problems in the art and many deficiencies in the known products, which have severely limited their commercial usefulness. A major challenge in the design of an image-recording
15 element is to provide heat and humidity keeping.

It is an object of this invention to provide a multilayer ink recording element that has excellent image quality and improved humidity keeping.

Still another object of the invention is to provide a printing method
20 using the above-described element.

SUMMARY OF THE INVENTION

These and other objects are achieved by the present invention which comprises an inkjet recording element comprising a support having thereon a ink-receiving layer comprising a hydrophilic polymer and particles of an
25 aluminosilicate as described below in an amount of at least 5 but less than 30 percent by weight of solids in the layer.

Such recording elements, which comprise one or more non-porous (swellable) hydrophilic absorbing layers, exhibit improved humidity keeping and excellent image quality.

In a preferred embodiment of the invention, the ratio of hydrophilic polymer to the aluminosilicate particles is about from about 95:5 to about 70:30. The hydrophilic polymer is preferably poly(vinyl alcohol).

Another embodiment of the invention relates to an inkjet printing method comprising the steps of: A) providing an inkjet printer that is responsive to digital data signals; B) loading the inkjet printer with the inkjet recording element described above; C) loading the inkjet printer with an inkjet ink; and D) printing on the inkjet recording element using the inkjet ink in response to the digital data signals.

As used herein, the terms "over," "above," and "under" and the like, with respect to layers in the inkjet media, refer to the order of the layers over the support, but do not necessarily indicate that the layers are immediately adjacent or that there are no intermediate layers.

DETAILED DESCRIPTION OF THE INVENTION

As noted above, at least one hydrophilic absorbing layer (or ink-receiving layer) comprises a natural or synthetic polymer. Preferred is a hydrophilic absorbing layer comprising gelatin or poly (vinyl alcohol) (PVA). This layer may also contain other hydrophilic materials such as naturally-occurring hydrophilic colloids and gums such as albumin, guar, xanthan, acacia, chitosan, starches and their derivatives, functionalized proteins, functionalized gums and starches, and cellulose ethers and their derivatives, polyvinylloxazoline, such as poly(2-ethyl-2-oxazoline) (PEOX), polyvinylmethyloxazoline, polyoxides, polyethers, poly(ethylene imine), poly(acrylic acid), poly(methacrylic acid), n-vinyl amides including polyacrylamide and polyvinyl pyrrolidinone (PVP), and poly(vinyl alcohol) derivatives and copolymers, such as copolymers of poly(ethylene oxide) and poly(vinyl alcohol) (PEO-PVA).

The gelatin used in the present invention may be made from animal collagen, but gelatin made from pig skin, cow skin, or cow bone collagen is preferable due to ready availability. The kind of gelatin is not specifically limited, but lime-processed gelatin, acid processed gelatin, amino group inactivated gelatin (such as acetylated gelatin, phthaloylated gelatin, malenoylated gelatin,

benzoylated gelatin, succinylated gelatin, methyl urea gelatin, phenylcarbamoylated gelatin, and carboxy modified gelatin), or gelatin derivatives (for example, gelatin derivatives disclosed in JP Patent publications 38-4854/1962, 39-5514.1964, 40-12237/1965, 42-26345/1967, and 2-13595/1990; 5 U.S. Patents 2,525,753, 2,594,293, 2,614,928, 2,763,639, 3,118,766, 3,132,945, 3,186,846, 3,312,553; and GB Patents 861,414 and 103, 189) can be used singly or in combination. Most preferred are pigskin or modified pigskin gelatins and acid processed osseine gelatins due to their effectiveness for use in the present invention.

10 The hydrophilic absorbing layer or layers must effectively absorb both the water and humectants commonly found in printing inks as well as the recording agent. In one embodiment of the invention, two or more hydrophilic absorbing layers may be present, including the ink-receiving layer and a base layer, the latter being between the support and the ink-receiving layer. The upper 15 ink-receiving layer, the base layer, and any other hydrophilic absorbing layers such as an overcoat will collectively be referred to as the hydrophilic absorbing layers. In one embodiment of the present invention, the base layer comprises gelatin, and the other comprises one or more hydrophilic material selected from naturally-occurring hydrophilic colloids and gums such as albumin, guar, xanthan, acacia, 20 chitosan, starches and their derivatives, functionalized proteins, functionalized gums and starches, cellulose ethers and their derivatives, polyvinylloxazoline, such as poly(2-ethyl-2-oxazoline) (PEOX), non-modified gelatins, polyvinylmethyloxazoline, polyoxides, polyethers, poly(ethylene imine), n-vinyl amides including polyacrylamide and polyvinyl pyrrolidinone (PVP), poly(vinyl 25 alcohol) and poly(vinyl alcohol) derivatives and copolymers, such as copolymers of poly(ethylene oxide) and poly(vinyl alcohol) (PEO-PVA), polyurethanes, and polymer latices such as polyesters and acrylates. Derivatized poly(vinyl alcohol) includes, but is not limited to, polymers having at least one hydroxyl group replaced by ether or ester groups which may be used in the invention may 30 comprise an acetoacetylated poly(vinyl alcohol) in which the hydroxyl groups are esterified with acetoacetic acid.

In one embodiment of the invention, the hydrophilic absorbing layers comprise a first (lower) hydrophilic absorbing layer, a base layer comprising gelatin, and at least one upper layer or second hydrophilic absorbing layer (also referred to as the "ink-receiving layer"), located between the base layer and an optional overcoat layer, comprising poly(vinyl alcohol). These embodiments provide enhanced image quality.

As noted above, the poly(vinyl alcohol) employed in the invention has a degree of hydrolysis of at least about 50% and has a number average molecular weight of at least about 45,000. In a preferred embodiment of the invention, the poly(vinyl alcohol) has a degree of hydrolysis of about 70 to 99%, more preferably about 75 to 90%. Commercial embodiments of such a poly(vinyl alcohol) include Gohsenol ® AH-22, Gohsenol ® AH-26, Gohsenol ® KH-20, and Gohsenol ® GH-17 from Nippon Gohsei and Elvanol®52-22 from DuPont (Wilmington, DE).

The dry layer thickness of the ink-receiving layer is preferably from 0.5 to 15 µm (more preferably 1 to 10 microns). The preferred dry coverage of an optional overcoat layer is from 0.5 to 5 µm (more preferably 0.5 to 1.5 microns) as is common in practice. In general, the dry layer thickness of a base layer, if present, is preferably from 5 to 60 microns (more preferably 6 to 15 microns), below which the layer is too thin to be effective and above which no additional gain in performance is noted with increased thickness.

The binder for the optional overcoat can be any of the polymers mentioned above for the hydrophilic absorbing layers. In a preferred embodiment of the invention, the overcoat comprises poly(vinyl alcohol), hydroxypropyl cellulose, hydroxypropyl methyl cellulose, gelatin, and/or a poly(alkylene oxide). In a still more preferred embodiment, the hydrophilic binder in the overcoat is poly(vinyl alcohol). This layer may also contain other hydrophilic materials such as cellulose derivatives, e.g., cellulose ethers like methyl cellulose (MC), ethyl cellulose, hydroxypropyl cellulose (HPC), sodium carboxymethyl cellulose (CMC), calcium carboxymethyl cellulose, methylethyl cellulose, methylhydroxyethyl cellulose, hydroxypropylmethyl cellulose (HPMC),

hydroxybutylmethyl cellulose, ethylhydroxyethyl cellulose, sodium
carboxymethyl-hydroxyethyl cellulose, and carboxymethylethyl cellulose, and
cellulose ether esters such as hydroxypropylmethyl cellulose phthalate,
hydroxypropylmethyl cellulose acetate succinate, hydroxypropyl cellulose acetate,
5 esters of hydroxyethyl cellulose and diallyldimethyl ammonium chloride, esters of
hydroxyethyl cellulose and 2-hydroxypropyltrimethylammonium chloride and
esters of hydroxyethyl cellulose and a lauryldimethylammonium substituted
epoxide (HEC-LDME), such as Quatrisoft® LM200 (Amerchol Corp.) as well as
hydroxyethyl cellulose grafted with alkyl C₁₂-C₁₄ chains. The overcoat is non-
10 porous. Optionally, particles or beads, inorganic or organic, can be present in the
overcoat in an amount up to about 40 weight percent total solids. Such particles
can be used for various purposes, to increase solids, to provide a matte finish, as a
filler, as a viscosity reducer, and/or to increase smudge resistance. The use of
aluminosilicate particles to increase smudge resistance is disclosed in U.S. Serial
15 No. 10/705,057 by Charles E. Romano, Jr., et al., titled "Ink Jet Recording Element
and Printing element" filed November 10, 2003, hereby incorporated by reference
in its entirety.

The ink-receiving layer comprises from about 5 to 30 percent by
weight solids of particles of a synthetic aluminosilicate material, preferably about
20 8 to 20, more preferably 10 to 18 wt % of the overcoat solids. The aluminosilicate
is similar to natural allophane, but is a synthetically produced material not derived
from a natural or purified natural aluminosilicate material and that is substantially
amorphous. In one embodiment the particles are in the form of spheres or rings,
preferably substantially spherical spheres 1 to 10 nm in average diameter, as
25 observable under an electron microscope. It is a polymeric aluminosilicate
material having the formula:



where the ratio of x:y is between 0.5 and 4, a and b are selected such that the rule
of charge neutrality is obeyed; and n is between 0 and 10.

30 In a preferred embodiment, the polymeric aluminosilicate has the
formula:



where the ratio of x:y is between 1 and 3.6, preferably 1 to 3, more preferably 1 to 2, and a and b are selected such that the rule of charge neutrality is obeyed; and n is between 0 and 10. More preferably, it is a substantially amorphous

5 aluminosilicate, spherical or ring shaped, with a general molar ratio of Al to Si not more than 2:1.

The polymeric aluminosilicate can be obtained by the controlled hydrolysis by an aqueous alkali solution of a mixture of an aluminum compound such as halide, perchloric, nitrate, sulfate salts or alkoxides species $\text{Al}(\text{OR})_3$, and a
10 silicon compound such as alkoxides species, wherein the molar ratio Al/Si is maintained between 1 and 3.6 and the alkali/Al molar ratio is maintained between 2.3 and 3. Such materials are described in French patent application FR 02/9085, hereby incorporated by reference in its entirety.

The polymeric aluminosilicate can be obtained by the controlled
15 hydrolysis by an aqueous alkali solution of a mixture of an aluminum compound such as halide, perchloric, nitrate, sulfate salts or alkoxides species $\text{Al}(\text{OR})_3$ and a silicon compound made of mixture of tetraalkoxide $\text{Si}(\text{OR})_4$ and organotrialkoxide $\text{R}'\text{Si}(\text{OR})_3$, wherein the molar ratio is maintained between 1 and 3.6 and the alkali/Al molar ratio is maintained 2.3 and 3. Such materials are described in
20 French patent application FR 02/9086, hereby incorporated by reference in its entirety.

Synthetic hollow aluminosilicates are disclosed in U.S. Patent No. 6,254,845 issued July 3, 2001 to Ohashi et al, titled "Synthesis Method Of Spherical Hollow Aluminosilicate Cluster," hereby incorporated by reference. As
25 mentioned earlier, the method used therein results in a synthetic allophane in which powder X-ray diffraction reveals two broad peaks close to 27° and 40° at 2θ on the $\text{Cu-K}\alpha$ line, which correspond to a non-crystalline (substantially amorphous) structure and which is characteristic of spherical particles referred to as allophane. In some cases, allophanes have also been characterized as giving
30 weak XRD peaks at least at about 2.2 and 3.3 . The method of synthesis may

affect the XRD pattern, however, and depending on the preparation, additional peaks may be present at about 7.7 to 8.4 Å and/or about 1.40 Å.

The aluminosilicate of the present invention includes materials termed "synthetic allophane" or "allophane like." Synthetic allophane is typically
5 in the form of substantially spherically or ring shaped aluminosilicate particles, including hollow spherical aluminosilicate particles, preferably having an average diameter of between 3.5 and 5.5 nm. In addition, synthetic allophanes, like natural allophanes, are substantially amorphous (P. Bayliss, Can. Mineral. Mag., 1987, 327), compared to, for example, imogolites which are crystalline and fibril shaped.
10 Synthetic allophane differs from natural allophane (such as Allophosite® sold by Sigma) in that it does not contain iron. It may also be more amorphous and acidic.

In more detail, a preferred method for preparing an aluminosilicate polymer comprises the following steps:

(a) treating a mixed aluminum and silicon alkoxide only
15 comprising hydrolyzable functions, or a mixed aluminum and silicon precursor resulting from the hydrolysis of a mixture of aluminum compounds and silicon compounds only comprising hydrolyzable functions, with an aqueous alkali, in the presence of silanol groups, the aluminum concentration being maintained at less than 1.0 mol/l, the Al/Si molar ratio being maintained between 1 and 3.6 and the
20 alkali/Al molar ratio being maintained between 2.3 and 3;

(b) stirring the mixture resulting from step (a) at ambient temperature in the presence of silanol groups long enough to form the aluminosilicate polymer; and

(c) eliminating the byproducts formed during steps (a) and (b)
25 from the reaction medium.

The expression "hydrolyzable function" means a substituent eliminated by hydrolysis during the process and in particular at the time of treatment with the aqueous alkali. The expression "unmodified mixed aluminum and silicon alkoxide" or "unmodified mixed aluminum and silicon precursor"
30 means respectively a mixed aluminum and silicon alkoxide only having hydrolyzable functions, or a mixed aluminum and silicon precursor resulting from

the hydrolysis of a mixture of aluminum compounds and silicon compounds only having hydrolyzable functions. More generally, an "unmodified" compound is a compound that only comprises hydrolyzable substituents.

Step (c) can be carried out according to different well-known
5 methods, such as washing or diafiltration.

The aluminosilicate polymer material obtainable by the method defined above has a substantially amorphous structure shown by electron diffraction. This material is characterized in that its Raman spectrum comprises in spectral region 200-600 cm^{-1} a wide band at $250 \pm 6 \text{ cm}^{-1}$, a wide intense band at
10 $359 \pm 6 \text{ cm}^{-1}$, a shoulder at $407 \pm 7 \text{ cm}^{-1}$, and a wide band at $501 \pm 6 \text{ cm}^{-1}$, the Raman spectrum being produced for the material resulting from step (b) and before step (c).

Alternatively, hybrid aluminosilicate polymers involving the introduction of functions, in particular organic functions into the inorganic
15 aluminosilicate polymer enables a hybrid aluminosilicate polymer to be obtained in comparison to inorganic aluminosilicate polymers. A method for preparing a hybrid aluminosilicate polymer, comprises the following steps:

(a) treating a mixed aluminum and silicon alkoxide of which the silicon has both hydrolyzable substituents and a non-hydrolyzable substituent, or a
20 mixed aluminum and silicon precursor resulting from the hydrolysis of a mixture of aluminum compounds and silicon compounds only having hydrolyzable substituents and silicon compounds having a non-hydrolyzable substituent, with an aqueous alkali, in the presence of silanol groups, the aluminum concentration being maintained at less than 0.3 mol/l, the Al/Si molar ratio being maintained
25 between 1 and 3.6 and the alkali/Al molar ratio being maintained between 2.3 and 3;

(b) stirring the mixture resulting from step (a) at ambient temperature in the presence of silanol groups long enough to form the hybrid aluminosilicate polymer; and

30 (c) eliminating the byproducts formed during steps (a) and (b) from the reaction medium.

The expression "non-hydrolyzable substituent" means a substituent that does not separate from the silicon atom during the process and in particular at the time of treatment with the aqueous alkali. Such substituents are for example hydrogen, fluoride or an organic group. On the contrary the expression

5 "hydrolyzable substituent" means a substituent eliminated by hydrolysis in the same conditions. The expression "modified mixed aluminum and silicon alkoxide" means a mixed aluminum and silicon alkoxide in which the aluminum atom only has hydrolyzable substituents and the silicon atom has both hydrolyzable substituents and a non-hydrolyzable substituent. Similarly, the

10 expression "modified mixed aluminum and silicon precursor" means a precursor obtained by hydrolysis of a mixture of aluminum compounds and silicon compounds only having hydrolyzable substituents and silicon compounds having a non-hydrolyzable substituent. This is the non-hydrolyzable substituent that will be found again in the hybrid aluminosilicate polymer material of the present

15 invention. More generally, an "unmodified" compound is a compound that only consists of hydrolyzable substituents and a "modified" compound is a compound that consists of a non-hydrolyzable substituent. This material is characterized by a Raman spectrum similar to the material obtained in the previous synthesis, as well as bands corresponding to the silicon non-hydrolyzable substituent (bands linked

20 to the non-hydrolyzable substituent can be juxtaposed with other bands), the Raman spectrum being produced for the material resulting from step (b) and before step (c).

The aluminosilicate of the present invention has several desirable properties. Most importantly, it very clearly maintains print sharpness following

25 exposure to heat and humidity (preventing dye bleed).

Referring again to the hydrophilic absorbing layers, dye mordants are added to at least the ink-receiving layer, optionally also in the optional base layer and/or the optional overcoat, in order to improve water and humidity resistance throughout the ink-recording element. Any polymeric mordant can be

30 used in the hydrophilic absorbing layer or layers of the invention provided it does not adversely affect light fade resistance unduly. Preferably, for example, there

may be used a cationic polymer, e.g., a polymeric quaternary ammonium compound, such as poly(dimethylaminoethyl)-methacrylate, polyalkylenepolyamines, and products of the condensation thereof with dicyanodiamide, amine-epichlorohydrin polycondensates, lecithin and
5 phospholipid compounds. Examples of mordants useful in the invention include vinylbenzyl trimethyl ammonium chloride/ethylene glycol dimethacrylate, vinylbenzyl trimethyl ammonium chloride/divinyl benzene, poly(diallyl dimethyl ammonium chloride), poly(2-N,N,N-trimethylammonium)ethyl methacrylate methosulfate, poly(3-N,N,N-trimethyl-ammonium)propyl methacrylate chloride, a
10 copolymer of vinylpyrrolidinone and vinyl(N-methylimidazolium chloride, and hydroxyethyl cellulose derivitized with (3-N,N,N-trimethylammonium)propyl chloride.

Preferably, at least the ink-receiving layer and optionally both the ink-receiving layer and a base layer contains a cationic polymer comprising an
15 effective amount of a cationic monomeric unit (mordant moiety). The cationic polymer can be water-soluble or can be in the form of a latex, water dispersible polymer, beads, or core/shell particles wherein the core is organic or inorganic and the shell in either case is a cationic polymer. Such particles can be products of addition or condensation polymerization, or a combination of both. They can be
20 linear, branched, hyper-branched, grafted, random, blocked, or can have other polymer microstructures well known to those in the art. They also can be partially crosslinked. Examples of core/shell particles useful in the invention are disclosed in U.S. Patent No. 6,619,797 issued September 16, 2003 to Lawrence et al., titled "Inkjet Printing Method." Examples of water-dispersible particles useful
25 in the invention are disclosed in U.S. Patent No. 6,454,404 issued September 24, 2002 to Lawrence et al., titled "Inkjet Printing Method," and U.S. Patent No. 6,503,608 issued January 7, 2003 to Lawrence et al., titled "Inkjet Printing Method."

Preferably, cationic, polymeric particles comprising at least 10
30 mole percent of a cationic mordant moiety (monomeric unit) are employed in the ink-receiving layer.

Such cationic, polymeric particles useful in the invention can be derived from nonionic, anionic, or cationic monomers. In a preferred embodiment, combinations of nonionic and cationic monomers are employed. The nonionic, anionic, or cationic monomers employed can include neutral,
5 anionic or cationic derivatives of addition polymerizable monomers such as styrenes, alpha-alkylstyrenes, acrylate esters derived from alcohols or phenols, methacrylate esters [usually referred to as methacrylate], vinylimidazoles, vinylpyridines, vinylpyrrolidinones, acrylamides, methacrylamides, vinyl esters derived from straight chain and branched acids (e.g., vinyl acetate), vinyl ethers
10 (e.g., vinyl methyl ether), vinyl nitriles, vinyl ketones, halogen-containing monomers such as vinyl chloride, and olefins, such as butadiene.

The nonionic, anionic, or cationic monomers employed can also include neutral, anionic or cationic derivatives of condensation polymerizable monomers such as those used to prepare polyesters, polyethers, polycarbonates,
15 polyureas and polyurethanes.

The water insoluble, cationic, polymeric particles employed in this invention can be prepared using conventional polymerization techniques including, but not limited to bulk, solution, emulsion, or suspension polymerization. They are also commercially available usually from a variety of
20 sources.

The amount of water insoluble, cationic, polymeric particles used, especially in the ink-receiving layer, should be high enough so that the images printed on the recording element will have a sufficiently high density. In a preferred embodiment of the invention, the cationic, polymeric particles are used
25 in the amount of 5 to 30 weight percent solids, preferably 10 to 20 weight percent in the ink-receiving layer. If present, an optional base layer may contain an amount of mordant particles in the same range.

Examples of other water insoluble, cationic, polymeric particles which may be used in the invention include those described in U.S. Patent No.
30 3,958,995, hereby incorporated by reference in its entirety. Specific examples of these polymers include, for example, a copolymer of

(vinylbenzyl)trimethylammonium chloride and divinylbenzene (87:13 molar ratio); a terpolymer of styrene, (vinylbenzyl)dimethylbenzylamine and divinylbenzene (49.5:49.5:1.0 molar ratio); and a terpolymer of butyl acrylate, 2-aminoethylmethacrylate hydrochloride and hydroxyethylmethacrylate (50:20:30 molar ratio).

The support for the inkjet recording element used in the invention can be any of those usually used for inkjet receivers, such as resin-coated paper, paper, polyesters, or microporous materials such as polyethylene polymer-containing material sold by PPG Industries, Inc., Pittsburgh, Pennsylvania under the trade name of Teslin ®, Tyvek ® synthetic paper (DuPont Corp.), and OPPalylte® films (Mobil Chemical Co.) and other composite films listed in U.S. Patent No. 5,244,861. Opaque supports include plain paper, coated paper, synthetic paper, photographic paper support, melt-extrusion-coated paper, and laminated paper, such as biaxially oriented support laminates. Biaxially oriented support laminates are described in U.S. Patent Nos. 5,853,965; 5,866,282; 5,874,205; 5,888,643; 5,888,681; 5,888,683; and 5,888,714. These biaxially oriented supports include a paper base and a biaxially oriented polyolefin sheet, typically polypropylene, laminated to one or both sides of the paper base. Transparent supports include glass, cellulose derivatives, e.g., a cellulose ester, cellulose triacetate, cellulose diacetate, cellulose acetate propionate, cellulose acetate butyrate; polyesters, such as poly(ethylene terephthalate), poly(ethylene naphthalate), poly(1,4-cyclohexanedimethylene terephthalate), poly(butylene terephthalate), and copolymers thereof; polyimides; polyamides; polycarbonates; polystyrene; polyolefins, such as polyethylene or polypropylene; polysulfones; polyacrylates; polyetherimides; and mixtures thereof. The papers listed above include a broad range of papers, from high end papers, such as photographic paper to low end papers, such as newsprint. In a preferred embodiment, polyethylene-coated or poly(ethylene terephthalate) paper is employed.

The support used in the invention may have a thickness of from 50 to 500 µm, preferably from 75 to 300 µm. Antioxidants, antistatic agents,

plasticizers and other known additives may be incorporated into the support, if desired.

In order to improve the adhesion of the base layer or, in the absence of a base layer, the ink-receiving layer, to the support, the surface of the support may be subjected to a corona-discharge treatment prior to applying a subsequent layer. The adhesion of the ink recording layer to the support may also be improved by coating a subbing layer on the support. Examples of materials useful in a subbing layer include halogenated phenols and partially hydrolyzed vinyl chloride-co-vinyl acetate polymer.

Coating compositions employed in the invention may be applied by any number of well known techniques, including dip-coating, wound-wire rod coating, doctor blade coating, gravure and reverse-roll coating, slide coating, bead coating, extrusion coating, curtain coating and the like. Known coating and drying methods are described in further detail in Research Disclosure No. 308119, published Dec. 1989, pages 1007 to 1008. Slide coating is preferred, in which the base layers and overcoat may be simultaneously applied. After coating, the layers are generally dried by simple evaporation, which may be accelerated by known techniques such as convection heating.

To improve colorant fade, UV absorbers, radical quenchers or antioxidants may also be added to the image-receiving layer as is well known in the art. Other additives include pH modifiers, adhesion promoters, rheology modifiers, surfactants, biocides, lubricants, dyes, optical brighteners, matte agents, antistatic agents, etc. In order to obtain adequate coatability, additives known to those familiar with such art such as surfactants, defoamers, alcohol and the like may be used. A common level for coating aids is 0.01 to 0.30 % active coating aid based on the total solution weight. These coating aids can be nonionic, anionic, cationic or amphoteric. Specific examples are described in MCCUTCHEON's Volume 1: Emulsifiers and Detergents, 1995, North American Edition.

Matte particles may be added to any or all of the layers described in order to provide enhanced printer transport, resistance to ink offset, or to change

the appearance of the ink receiving layer to satin or matte finish. In addition, surfactants, defoamers, or other coatability-enhancing materials may be added as required by the coating technique chosen.

In another embodiment of the invention, a filled layer containing
5 light scattering particles such as titania may be situated between a clear support material and the ink receptive multilayer described herein. Such a combination may be effectively used as a backlit material for signage applications. Yet another embodiment which yields an ink receiver with appropriate properties for backlit display applications results from selection of a partially voided or filled
10 poly(ethylene terephthalate) film as a support material, in which the voids or fillers in the support material supply sufficient light scattering to diffuse light sources situated behind the image.

Optionally, an additional backing layer or coating may be applied to the backside of a support (i.e., the side of the support opposite the side on
15 which the image-recording layers are coated) for the purposes of improving the machine-handling properties and curl of the recording element, controlling the friction and resistivity thereof, and the like.

Typically, the backing layer may comprise a binder and a filler. Typical fillers include amorphous and crystalline silicas, poly(methyl
20 methacrylate), hollow sphere polystyrene beads, micro-crystalline cellulose, zinc oxide, talc, and the like. The filler loaded in the backing layer is generally less than 5 percent by weight of the binder component and the average particle size of the filler material is in the range of 5 to 30 μm . Typical binders used in the backing layer are polymers such as polyacrylates, gelatin, polymethacrylates,
25 polystyrenes, polyacrylamides, vinyl chloride-vinyl acetate copolymers, poly(vinyl alcohol), cellulose derivatives, and the like. Additionally, an antistatic agent also can be included in the backing layer to prevent static hindrance of the recording element. Particularly suitable antistatic agents are compounds such as dodecylbenzenesulfonate sodium salt, octylsulfonate potassium salt,
30 oligostyrenesulfonate sodium salt, laurylsulfosuccinate sodium salt, and the like. The antistatic agent may be added to the binder composition in an amount of 0.1

to 15 percent by weight, based on the weight of the binder. An image-recording layer may also be coated on the backside, if desired.

While not necessary, the hydrophilic material layers described above may also include a cross-linker. Such an additive can improve the adhesion of the ink receptive layer to the substrate as well as contribute to the cohesive strength and water resistance of the layer. Cross-linkers such as carbodiimides, polyfunctional aziridines, melamine formaldehydes, isocyanates, epoxides, and the like may be used. If a cross-linker is added, care must be taken that excessive amounts are not used as this will decrease the swellability of the layer, reducing the drying rate of the printed areas.

The coating composition can be coated either from water or organic solvents, however water is preferred. The total solids content should be selected to yield a useful coating thickness in the most economical way, and for particulate coating formulations, solids contents from 10-40% are typical.

Inkjet inks used to image the recording elements of the present invention are well-known in the art. The ink compositions used in inkjet printing typically are liquid compositions comprising a solvent or carrier liquid, dyes or pigments, humectants, organic solvents, detergents, thickeners, preservatives, and the like. The solvent or carrier liquid can be solely water or can be water mixed with other water-miscible solvents such as polyhydric alcohols. Inks in which organic materials such as polyhydric alcohols are the predominant carrier or solvent liquid may also be used. Particularly useful are mixed solvents of water and polyhydric alcohols. The dyes used in such compositions are typically water-soluble direct or acid type dyes. Such liquid compositions have been described extensively in the prior art including, for example, U.S. Patent Nos. 4,381,946; 4,239,543; and 4,781,758.

The following example is provided to illustrate the invention.

Preparation 1

This example illustrates the preparation of an aluminosilicate that can be employed in the present invention. Osmosed water in the amount of 100 l was poured into a plastic (polypropylene) reactor. Then, 4.53 moles AlCl_3 , $6\text{H}_2\text{O}$,

and then 2.52 moles tetraethyl orthosilicate were added. This mixture was stirred and circulated simultaneously through a bed formed of 1 kg of glass beads, 2-mm diameter, using a pump with 8-l/min output. The operation to prepare the unmodified mixed aluminum and silicon precursor took 90 minutes. Then, 10.5
5 moles NaOH 3M were added to the contents of the reactor in two hours. Aluminum concentration was 4.4×10^{-2} mol/l, Al/Si molar ratio 1.8 and alkali/Al ratio 2.31. The reaction medium clouded. The mixture was stirred for 48 hours. The medium became clear. The circulation was stopped in the glass bead bed. The aluminosilicate polymer material according to the present invention was thus
10 obtained in dispersion form. Finally, nanofiltration was performed to pre-concentration by a factor of 3, followed by diafiltration using a Filmtec® NF 2540 nanofiltration membrane (surface area 6 m²) to eliminate the sodium salts to obtain an Al/Na ratio greater than 100. The retentate resulting from the diafiltration by nanofiltration was concentrated to obtain a gel with about 20% by
15 weight of aluminosilicate polymer.

Preparation 2

Another example of the preparation of aluminosilicate particles was as follows. Demineralized water in the amount of 56 kg was poured into a glass reactor. Then, 29 moles AlCl₃•6H₂O, were dissolved in the water and the reactor
20 was heated to 40°C. Then, 19.3 moles tetraethyl orthosilicate were added. This mixture was stirred for 15 minutes. Next, 74.1 moles of triethylamine were metered into the mixture in 75 minutes. The mixture was allowed to stir overnight. The mixture was diafiltered with a 20K MWCO spiral wound polysulfone membrane (Osmonics® model S8J) until the conductivity of the
25 permeate was less than 1000 µS/cm. The reaction mixture was then concentrated by ultrafiltration. The yield was 41.3 kg at 6.14% solids (95%).

EXAMPLE 1

Control Coating Solution 1 – A liquid solution was made by dissolving a partially hydrolyzed polyvinyl alcohol (GH-17® from Nippon
30 Gohsei) in water and adding two coating surfactants (Olin 10G® from Olin Corp. and Zonyl FSN® from Dupont Corp.) with the ratios of dry chemicals being 99.7

parts GH17 to 0.15 parts Olin® 10G and 0.15 parts Zonyl® FSN. The solution is made at 6% solids in water.

Control Coating Solution 2 - Prepared in the same way as the Control Coating Solution 1 except that 30 parts of the GH-17 is replaced with the aluminosilicate as prepared above.

Control Coating Solution 3 - Prepared in the same way as the Control Coating Solution 1 except that 35 parts of the GH-17 is replaced with the aluminosilicate.

Control Coating Solution 4 - Prepared in the same way as the Control Coating Solution 1 except that 40 parts of the GH-17 is replaced with the aluminosilicate.

Control Coating Solution 5 - Prepared in the same way as the Control Coating Solution 1 except that 45 parts of the GH-17 is replaced with the aluminosilicate.

Control Coating Solution 6 - Prepared in the same way as the Control Coating Solution 1 except that 50 parts of the GH-17 is replaced with the aluminosilicate.

Invention Coating Solution 1 - Prepared in the same way as the Control Coating Solution 1 except that 5 parts of the GH-17 is replaced with the aluminosilicate.

Invention Coating Solution 2 - Prepared in the same way as the Control Coating Solution 1 except that 10 parts of the GH-17 is replaced with the aluminosilicate.

Invention Coating Solution 3 - Prepared in the same way as the Control Coating Solution 1 except that 15 parts of the GH-17 is replaced with the aluminosilicate.

Invention Coating Solution 4 - Prepared in the same way as the Control Coating Solution 1 except that 20 parts of the GH-17 is replaced with the aluminosilicate.

Invention Coating Solution 5 - Prepared in the same way as the Control Coating Solution 1 except that 25 parts of the GH-17 is replaced with the aluminosilicate.

Each of the coating solutions were then applied to corona discharge treated polyethylene resin coated paper using a slide hopper and dried thoroughly by forced air heat after application of the coating solutions. The coating solutions were applied to give a dry coating thickness of 8 microns.

Testing

A photographic image of four children sitting on a couch with a gray background behind them was captured as a jpeg file and imported into Corel® Draw. The photograph was printed on the coatings using an Epson® 825 inkjet printer using the glossy photo paper media type and photo quality setting. The prints were visually checked for initial print sharpness. The prints were then incubated at 38°C / 80% RH for 7 days and checked again for print sharpness. The results are shown below in Table 1.

TABLE 1

Coating Solution	Wt% Aluminosilicate	Initial Print Sharpness	38°C/80% RH Incubated Print Sharpness
Control 1	0	Good	No good
Control 2	30	Good	No good
Control 3	35	Good	No good
Control 4	40	No good	No good
Control 5	45	No good	No good
Control 6	50	No good	No good
Invention 1	5	Good	Good
Invention 2	10	Good	Good
Invention 3	15	Good	Good
Invention 4	20	Good	Good
Invention 5	25	Good	Good

The above table shows that the invention solutions (containing 5 to 25 wt % of the prepared synthetic aluminosilicate) are acceptable for both initial print and incubated print sharpness. In the absence of the aluminosilicate, no protection from heat and humidity was obtained. Without wishing to be bound by theory, at 40 wt. % or more of the aluminosilicate, not enough binder may be

present to absorb ink during printing. At between 30 and 40%, insufficient binder may be present as a contributor to preventing humidity bleeding of dyes, the poor print sharpness being due to dye bleeding. Accordingly, the Control Solutions with none, 30% and 35% of the prepared synthetic aluminosilicate were found
5 unacceptable for incubated print sharpness. The Control Solutions with 40, 45 and 50% of the synthetic aluminosilicate were unacceptable for incubated print sharpness and initial print sharpness.

CLAIMS:

1. An inkjet recording element comprising a support having thereon a non-porous ink-receiving layer comprising a hydrophilic binder and
5 particles of a synthetic, substantially amorphous aluminosilicate material in an amount of at least 5 weight percent and less than 30 weight percent, based on the solids weight of the ink-receiving layer, the synthetic, substantially amorphous aluminosilicate material having an average diameter, as primary particles, of 1 to 10 nm, wherein the synthetic, substantially amorphous aluminosilicate material
10 exhibits an X-ray diffraction pattern that comprises weak peaks at about 2.2 and 3.3 Å.
2. The inkjet recording element of claim 1 wherein the hydrophilic binder comprises poly(vinyl alcohol).
15
3. The inkjet recording element of claim 1 wherein the inkjet recording element further comprises a base layer located between the ink-receiving layer and the support.
- 20 4. The inkjet recording element of claim 1 wherein the inkjet recording element further comprises an overcoat.
5. The inkjet recording element of claim 1 wherein the synthetic, substantially amorphous aluminosilicate particles are substantially in the form of
25 hollow spheres.
6. The inkjet recording element of claim 1 wherein the synthetic, substantially amorphous aluminosilicate material is a synthetic allophane with essentially no iron atoms.
30

7. The inkjet recording element of claim 1 wherein the synthetic, substantially amorphous aluminosilicate material is a synthetic allophane having a positive charge.

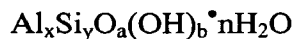
5 8. The inkjet recording element of claim 1 wherein the synthetic, substantially amorphous particles comprise a polymeric aluminosilicate having the formula:



where the ratio of x:y is between 0.5 and 4, a and b are selected such that the rule
10 of charge neutrality is obeyed; and n is between 0 and 10.

8. The inkjet recording element of claim 7 wherein the synthetic, substantially amorphous aluminosilicate comprises organic groups.

15 10. The inkjet recording element of claim 7 wherein the synthetic, substantially amorphous aluminosilicate has the formula:



where the ratio of x:y is between 1 and 3.6, and a and b are selected such that the
rule of charge neutrality is obeyed; and n is between 0 and 10.

20

11. The inkjet recording element of claim 1 wherein the average particle size of the synthetic, substantially amorphous particles is in the range from about 3 nm to about 6 nm.

25 12. The inkjet recording element of claim 1 wherein the synthetic, substantially amorphous aluminosilicate material is represented by the formula:



where the ratio of x:y is between 1 and 3.6, and a and b are selected such that the
30 rule of charge neutrality is obeyed; and n is between 0 and 10.

13. The inkjet recording element of claim 1 wherein the ink-receiving layer comprises a binder in the amount of at least 80 weight percent based on total solids.

5 14. The inkjet recording element of claim 1 where the ratio of hydrophilic binder to the aluminosilicate particles is about from about 95:5 to about 70:30.

10 15. An inkjet printing method, comprising the steps of:
A) providing an inkjet printer that is responsive to digital data signals;
B) loading the inkjet printer with the inkjet recording element of Claim 1;
C) loading the inkjet printer with an inkjet ink; and
15 D) printing on the inkjet recording element using the inkjet ink in response to the digital data signals.

ABSTRACT

An inkjet recording element comprising a support having thereon, in order, a support having thereon a ink-receiving layer comprising a hydrophilic
5 polymer and particles of an aluminosilicate in an amount of less than 30 weight percent solids, based on the total weight of the layer. Such recording elements exhibit improved humidity keeping for print sharpness.

Combined Declaration For Patent Application and Power of Attorney

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As below named inventor, I hereby declare that:

My residence, post office address and citizenship are as stated below next to my name,

I believe I am the original, first and sole inventor (if only one name is listed below) or an original, first and joint inventor (if plural names are listed below) of the subject matter which is claimed and for which a patent is sought on the invention entitled:

NON-POROUS INKJET RECORDING ELEMENT AND PRINTING METHOD

The specification of which (check only one item below):

☒ is attached hereto.

☐ was filed as United States Application Serial No. on and
was amended on (if applicable).

☐ was filed as PCT international application Number on and was amended on (if applicable).

I hereby state that I have reviewed and understand the contents of the above-identified specification, including the claims, as amended by any amendment referred to above.

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PCT APPLICATION NO.	PCT FILING DATE	U.S. SERIAL NUMBERS ASSIGNED (if any)		

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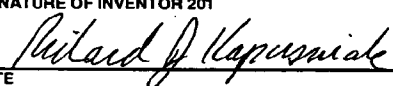
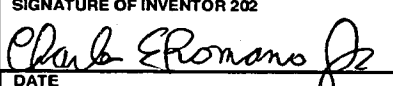
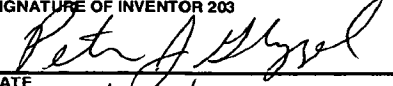
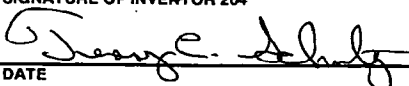
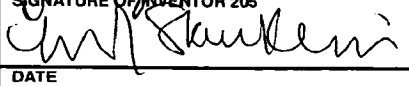
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DATE	DATE	DATE
January 16, 2004	January 16, 2004	1/16/04
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DATE	DATE	DATE
JANUARY 16, 2004	January 16, 2004	